

Work Order ID 127514

127514

Page 1

Item ID: D206-781-151KGY

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Vertical Tunnel-Grey

Stop ***NS2***

Start Date: 12/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/22/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-12-22 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100	Document Control	0.00	DAS 27 9-89					MLJ 150223	
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D206-781-151KGY (CHG 001)								
110	Pick Kit	0.00	DAS 27 9-89						
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MAR 16 2015

MAR 16 2015

FEB 13 2012

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127514***127514***

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Page 2

Item ID: D206-781-151KGY

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Vertical Tunnel-Grey

Stop ***NS2***

Start Date: 12/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/22/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Memo

0.00

MAR 16 2015

DAS
06
9-89

Packaging

Identify and pack for shipping as per PPP D206-781-151KGY
Location 16 118
PPP rev

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

MCS 15-03-18

Quality Control

15-3-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4632-130 *ALS4632-130* insert		Purchased	No			110	Each	998.0000	8	8		DAS 27 9-89 FEB 23 2015	DAS 28 9-89
				<u>Location</u> ST550				<u>Loc Qty</u> 998 998		<u>Loc Code</u>			
ALS4-632-80 *ALS4-632-80* Insert		Purchased	No		18908	110	Each	64.0000	4	4		DAS 27 9-89 FEB 23 2015	DAS 28 9-89
				<u>Location</u> ST550				<u>Loc Qty</u> 64 64		<u>Loc Code</u>			
D3800-1-100 *D3800-1-100* Hook And Loop Strip (1" Soft)		Manufactured	No		m130822	110	f	300.0000	13.3	14		DAS 27 9-89 FEB 23 2015	DAS 28 9-89
				<u>Location</u> ST419				<u>Loc Qty</u> 300 300		<u>Loc Code</u>			
D3800-3-100 *D3800-3-100* Hook And Loop Strip (1" Hard)		Manufactured	No		124095	110	f	75.0000	13.3	14		DAS 27 9-89 FEB 23 2015	DAS 28 9-89
				<u>Location</u> ST419				<u>Loc Qty</u> 75 75		<u>Loc Code</u>			
D3822-1KGY *D3822-1KGY* Vertical Tunnel, LH		Manufactured	No		124096	110	Each	0.0000	1	1		DAS 27 9-89 FEB 23 2015	DAS 28 9-89
				<u>Location</u> ST419				<u>Loc Qty</u> 75 75		<u>Loc Code</u>			

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
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Material									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 2

Work Order ID: 127514

Parent Item: D206-781-151KGY

Parent Item Name: Vertical Tunnel-Grey

127514

D206-781-151KGY

Start Date: 12/17/14

Required Date: 12/22/14

Start Qty: 1.00

Required Qty: 1.00

D3822-2KGY

Manufactured No

110

Each

0.0000

1

FEB 23 2015

DAS

06

9-89

DAS

28

9-89

Vertical Tunnel, RH

D3822-3KGY

Manufactured No

110

Each

0.0000

1

FEB 23 2015

DAS

06

9-89

DAS

28

9-89

Vertical Tunnel, Aft Center-Grey

D3822-5KGY

Manufactured No

110

Each

0.0000

1

FEB 23 2015

DAS

06

9-89

DAS

28

9-89

Vertical Tunnel, Top

D3822-7KGY

Manufactured No

110

Each

0.0000

1

FEB 23 2015

DAS

06

9-89

DAS

28

9-89

Vertical Tunnel, Lower-Grey

NAS388-6-12P

Purchased No

110

Each

51.0000

14

FEB 23 2015

DAS

06

9-89

DAS

28

9-89

SCREW

NAS388-6-8P

Purchased No

110

Each

22.0000

4

FEB 23 2015

DAS

06

9-89

DAS

28

9-89

SCREW

NAS391B6P

Purchased No

110

Each

69.0000

18

FEB 23 2015

DAS

06

9-89

DAS

28

9-89

Washer

Location

Loc Qty

Loc Code

ST264

51

m127580

51

22.0000

4

Location

Loc Qty

Loc Code

ST264

22

m130820

22

69.0000

18

Location

Loc Qty

Loc Code

ST263

69

m130799

69

December-17-14 1:29:17 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled. ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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5.2 D206-781-141/-143/-151/-161/-171/-173/-191/-193 KITS

Qty -141	Qty -143	Qty -151	Qty -161	Qty -171	Qty -173	Qty -191	Qty -193	Part Number	Description
X								D206-781-141	CREW CABIN OVERHEAD W/O ROTOR BRAKE KIT
	X							D206-781-143	CREW CABIN OVERHEAD W/ ROTOR BRAKE KIT
		X						D206-781-151	VERTICAL TUNNEL KIT
			X					D206-781-161	REAR OVERHEAD KIT
				X				D206-781-171	HAT BIN KIT
					X			D206-781-173	HAT BIN KIT, LITTER KIT COMPATIBLE
						X		D206-781-191	CREW CABIN OVERHEAD W/ ROTOR BRAKE KIT
							X	D206-781-193	ROTOR BRAKE PANEL KIT
1								D3821-1	PANEL - W/O ROTOR BRAKE
	1							D3821-3	PANEL - W/ ROTOR BRAKE
4	4							NAS388-6-8P	SCREW
4	4							NAS391B6P	WASHER
		4						D3822-1	VERTICAL TUNNEL, LH
		4						D3822-2	VERTICAL TUNNEL, RH
		1						D3822-3	VERTICAL TUNNEL, AFT CENTER
		1						D3822-5	VERTICAL TUNNEL, TOP
		1						D3822-7	VERTICAL TUNNEL, LOWER
		2						D3800-3-100-800	LOOP STRIP
		2						D3800-3-100-800	HOOK STRIP
		4						NAS388-6-8P	SCREW
		12						NAS388-6-12P	SCREW
		18						NAS391B6P	WASHER
		8						ALS4-632-80	INSERT
		8						ALS4-682-130	INSERT
			1					D3823-1	REAR OVERHEAD, LH
			1					D3823-2	REAR OVERHEAD, RH
			1					D3823-3	REAR OVERHEAD, CENTER
			10					AN525-10R24	SCREW
			10					NAS43DD3-68	SPACER
				1				D3824-1	HAT BIN
					1			D3824-3	HAT BIN
				6	6			D3851-1	DOUBLER
				4	4			AN525-10R10	SCREW
						1		D4077-1	OVERHEAD PANEL, LH
						1		D4077-2	OVERHEAD PANEL, RH
							1	D4118-1	ROTOR BRAKE PANEL
						1		D4119-1	PANEL
						6		NAS388-6-8P	SCREW
							4	NAS388-6-12P	SCREW
						6	4	NAS391B6P	WASHER
							4	MS21059L06	NUTPLATE
							8	MS20426AD3-3	RIVET